Date:

Monday, 3/17/2008 12:00:27 PM

fiser

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Type

S.O. No. :

Job Number

: 38064

Estimate Number

: 11318

P.O. Number

: 3/17/2008 This Issue

: NC Prsht Rev. : // First Issue

Previous Run

: 34245

Written By

Checked & Approved By

Comment

: Est A 04.09.02 Est B 06.05.02

New issue KJ/JLM Water jet EC

: MACHINED PARTS

Drawing Name

: DOUBLER

Part Number

: D33023

Drawing Number

: D3302 REV B2 : N/A

Project Number **Drawing Revision**

: B2

Material

: 3/28/2008 **Due Date**

Qty:

10 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6S063

6061-T6 .063 Sheet

Comment: Qty.:

1.0428 sf(s)/Unit Total:

10.4276 sf(s)

6061-T6 .063 Sheet

Material: 6061-T6 (QQ-A-250/11) 0.063" thick

(M6061T6S.063) Identify for D3302-Batch:

2.0



Comment: FLOW WATER JET

1-Cut as per Dwg D3302

Dwg Rev: K Prog Rev:__

HB 8-3-24



2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



1B 8-3-24



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

Comment: SECOND CHECK

SECOND CHECK



Dart Aerospac	ce	Ltd
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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	By Date Qty Approval Chief Eng / Prod Mgr Approval QC Inspector								
·											
r professor											

Part No:	_ PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C C	losed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	A	A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
						,			
		e '		·					

NOTE: Date & initial all entries

Monday, 3/17/2008 12:00:28 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: DOUBLER Customer: CU-DAR001 Dart Helicopters Services Job Number: 38064 Part Number: D33023 Job Number: Seq. #: Description: Machine Or Operation: SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 5.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr break all unmarked sharp edges 0.005 to 0.010 6.0 Comment: NC BRAKE Form as per Dwg D3302 7.0 QC5 INSPECT WORK TO CURRENT STE Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #* 8.0 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION ne -04 10.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: QC21 11.0 08/04/109 Comment: FINAL INSPECTION/W/O RELEASE S. S. W. (0 Job Completion

Dart Aerospace Ltd

	•											
W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHAI	NGE	- By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
·												
Part No		PAR #:	Fault Categ	gory:								
			MODIZ ODDI	TO NON CONFORMA			a:	_ Date: _				
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NC	K)						
DATE	STEP	Description of NC		Corrective Action Section B		Verific	cation		Approval			
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	Section Sectio	on C	Chief Eng	QC Inspector			
	·											

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38064
Description: Doubler	Part Number:	D3302-3
Inspection Dwg: D3302 Rev: B2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.452	+/-0.010	14.452	*		Tape	
12.75	+/-0.030	19:75	¥		TAPA	
0.851	+/-0.010	-854	×		vern	
0.851	+/-0.010	.854	×		.)	
8.952	+/-0.010	8,950	×			
R0.12	+/-0.030	13.	¥			
7.250	+/-0.010	7. 247	¥		W .	
			-772-27			
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			,			
	1990 (1990)					
				7		

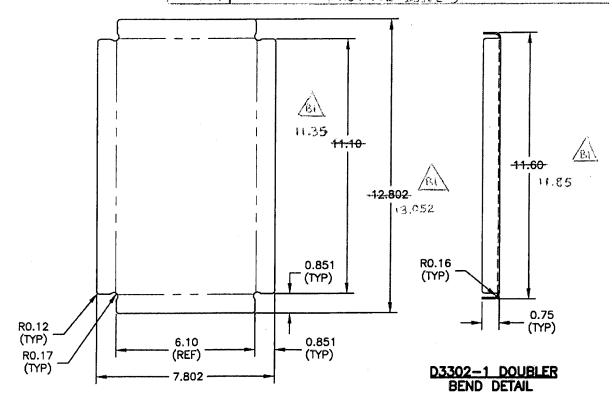
Measured by: 🖟	Audited by:		Prototype Approval:	N/A
Date: 8-3-24	Date:	JUGUS- 24	Date:	N/A

A 04.09.03 New Issue	KJ/JLM	
B 06.03.09 Dwg Rev update; Dimensions revised to revision B2	KJ/JLM	
C 07.01.16 Dimensions revised	KJ/JLM , ,	1
D 07.01.29 Dimensions revised	KJ/JLM	

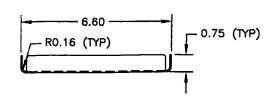


				The state of the s	
	DESIG	N T#	DRAWN BY	DART AEROSP HAWKESBURY, ONTARI	
	CHEC	KED	APPROVED	DRAWING NO.	REV. B
		#	— 	D3302	SHEET 1 OF 4
	DATE			TITLE	SCALE
	04.1	11.18		DOUBLER	1:4
	Α		04.07.06	NEW ISSUE	
	B	ر.	04.11.18	REMOVE HOLES	
1		<u> </u>			

B	04.11.18	REMOVE HOLES
Bi	# 7 04.12.15	ADDED 0.25" TO THE LEWSTH FOR -1/-3
B2		7.25 WAS 7.34: 8.952 WAS 9.042 17175 WAS



D3302-1 FLAT PATTERN



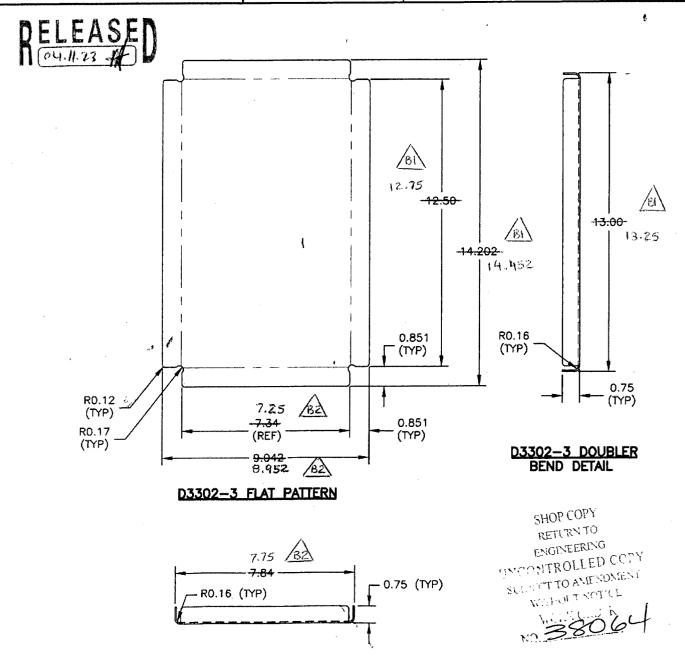
SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE NO. 3800

D3302-1 NOTES;

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063) 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER



DESIGN THE	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. 8
#	4	D3302	SHEET 2 OF 4
DATE		TITLE	SCALE
04.11.18		DOUBLER	1:4

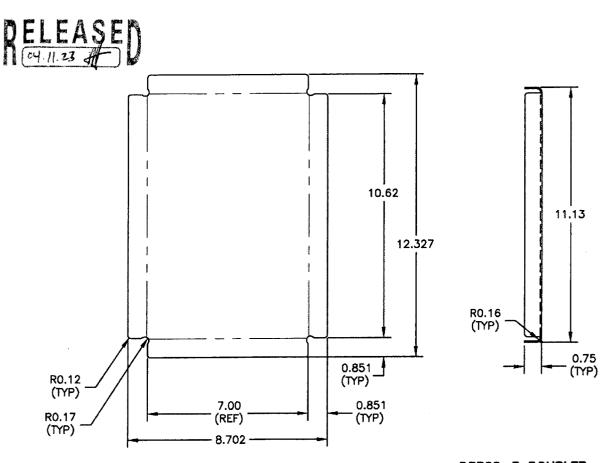


D3302-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063) 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & BATCH USING FINE POINT PERMANENT MARKER



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ,,	APPROVED /	DRAWING NO.	REV. B
#	 	D3302	SHEET 3 OF 4
DATE		TITLE	SCALE
04.11.08		DOUBLER	1:4



D3302-5 FLAT PATTERN

- 7.50 0.75 (TYP) R0.16 (TYP)

D3302-5 DOUBLER BEND DETAIL

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE ORK ORDER

D3302-5 NOTES:

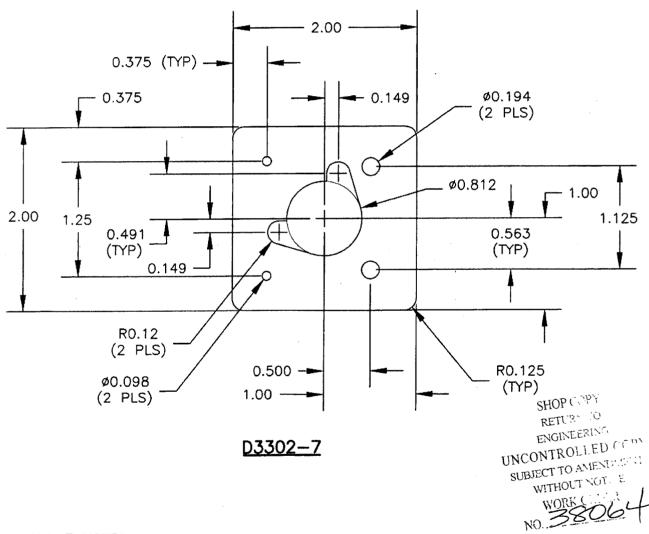
- MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 BREAK ALL SHARP EDGES 0.005 TO 0.010

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3302	REV. B SHEET 4 OF 4
DATE	1	TITLE	SCALE
04.11.18		DOUBLER	1:1





D3302-7 NOTES:

- 1) MATERIAL: 5052-H32 OR 6061-T6 (QQ-A-250/8 OR QQ-A-250/11) 0.040 THICK (REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER